

Please amend the claims as follows:

1. (currently amended) An process for making a deformable, hollow thermoplastic ~~article~~ doll head comprising:
 - (a) providing an injection moldable flexible thermoplastic elastomer;
 - (b) providing a first mold; the mold comprising exterior mold front and rear sections and an interior core which extends vertically through the first mold, the first mold comprising a parison injection station, wherein the exterior sections of the first mold are spaced apart from the interior core to define a cavity in the shape of a substantial portion of the ~~article~~ doll head;
 - (c) assembling the exterior mold sections of the first mold thereby forming a planar junction between the exterior mold parts;
 - (d) injecting the elastomer into the first mold cavity at a pressure of from about 200 psig to about 1,000 psig to form a parison;
 - (e) opening the exterior mold parts of the first mold and transferring the rear section of the first mold and the parison to a blow station;
 - (f) providing a second mold at the blow station, the second mold comprising an exterior mold front section, the rear section of the first mold, and an interior core, wherein the exterior mold front section and the rear section of the first mold exterior sections are oriented latitudinally relative to one another and wherein the exterior sections of the second mold are spaced apart from the interior core to define a cavity in the shape of the entirety of the hollow ~~article~~ doll head;
 - (g) drawing a vacuum on, and injecting compressed gas into, the second mold, thereby dispersing the parison relatively evenly, and with a substantially uniform thickness, against the second mold cavity interior surface to form the hollow ~~article~~ doll head, the hollow ~~article~~ doll head having an opening for removing the interior core, wherein the diameter of the opening ~~being smaller~~ is substantially narrower than the diameter of the core to pass through the opening;
 - (h) cooling the dispersed parison, thereby causing it to set and form the hollow article segment; and

(~~Ⓕ~~) (i) separating the second mold interior core from the hollow ~~article~~ doll head, wherein (I) the second mold cavity vacuum pressure ranges from about -7 psig to about -14.5 psig, the pressure of the compressed gas injected into the second mold ranges from about 80 psig to about 1,000 psig, the parison injection station temperature is from about 150°C to less than about 300°C, the temperature of the compressed gas injected into the second mold ranges from about 30°C to about 40°C, a vacuum is drawn upon the first mold cavity for about three to about ten seconds prior to the end of the elastomer injection period, the elastomer is injected into the first mold cavity over a period of from about 0.2 to about 6 seconds and the cooled and dispersed parison sets within the second mold in about 5 seconds to about 90 seconds; and (II) the doll head has a hair line which forms a substantially continuous circle extending around the top of the doll head, and the first mold interior core defines a cavity in the shape of the portion of the hollow doll head below the hair line.

2. (cancelled).

3. (cancelled).

4. (cancelled).

5. (cancelled).

6. (original) The process of claim 1, wherein the elastomer is a material selected from the group consisting of optionally hydrogenated styrene-ethylene/butylene-styrene (S-EB-S), styrene-butadiene-styrene (S-B-S), styrene-isopropene-styrene (S-I-S), styrene-diene, styrene-isoprene and styrene-butadiene block copolymers.

7. (original) The process of claim 1, wherein the elastomer is a KRATON® block copolymer having an elasticity ranging between about two hundred fifty to five hundred fifty percent.

8. (original) The process of claim 1, wherein (a) a vacuum is drawn on the second mold through a valve pin inserted through the second mold cavity, and (b) pressurized gas is injected into the second mold cavity through a movable core pin.

9. (previously presented) The process of claim 1, wherein a vacuum is drawn on, and compressed gas is injected into, the second mold at approximately the same time.

10. (currently amended) The process of claim 1, wherein:

~~(a) the deformable, hollow thermoplastic article is a hollow~~ doll head with has ears and a hair line, the hair line forming a substantially continuous circle extending around the top of the doll head and above the ears; ~~and~~

~~(b) the first mold interior core defines a cavity in the shape of the portion of the hollow doll head below the hair line.~~

11. (currently amended) The process of claim 1, wherein the interior core of the second mold includes a core ejector pin and a core sleeve surrounding the pin, and upon separation of the second mold interior core from the deformable hollow thermoplastic ~~article~~ doll head the core sleeve is retained in a fixed position relative to the ejector pin and the ejector pin is forced up against the deformable hollow thermoplastic ~~article~~ doll head to push the deformable hollow thermoplastic ~~article~~ doll head off of the core sleeve, thereby removing the deformable hollow thermoplastic ~~article~~ doll head from the ejector pin.

12. (currently amended) The process of claim 1 wherein the interior core of the second mold includes a hollow conduit in communication with the interior of the deformable hollow thermoplastic ~~article~~ doll head -forming cavity, and a pressurized gas is blown through the conduit and into the hollow interior of the deformable hollow thermoplastic ~~article~~ doll head to separate it from the second mold interior core.

13. (currently amended) The process of claim 1 wherein the second mold is designed with a pre-determined ratio of the diameter of the core relative to the diameter of the opening to allow removal of the core through the opening, said pre-determined ratio being less than a maximum stretchability limit of the opening of deformable hollow thermoplastic ~~article~~ doll head to be formed from the flexible thermoplastic elastomer.

14. (original) The process of claim 13, wherein the thermoplastic elastomer is a S-B-S copolymer, and the pre-determined ratio is more than about two.

15. (currently amended) The process of claim 1, further comprising: (a) placing a removable object onto the surface of the interior core of the second mold; (b) assembling the exterior parts of the second mold around the core and removable object; and (c) overmolding the removable object with the thermoplastic elastomer when the parison is dispersed within the second mold cavity interior surface, such that the removable object is retained in the deformable hollow thermoplastic-~~article~~ doll head when the interior core is removed.

16. (currently amended) The process of claim 15, wherein the thermoplastic elastomer overmolds only a portion of the removable object such that the removable object protrudes through the exterior surface of the deformable hollow thermoplastic ~~article~~ doll head.

17. (currently amended) The process of claim 16, wherein the removable object is a doll eye and the deformable hollow thermoplastic ~~article~~ is a doll head.

18. (currently amended) The process of claim 1, further comprising placing at least one portion of an exterior part of the first mold in contact with the interior core to define at least one opening to be formed in the deformable hollow thermoplastic ~~article~~ doll head.

19. (currently amended) The process of claim 18, further comprising placing an article into at least one of said openings formed by the contact between the exterior mold part and interior core after the deformable hollow thermoplastic ~~article~~ doll head is removed from the second mold interior core.

20. (original) The process of claim 10, further comprising removing the head from the second mold interior core, wherein the second mold interior core comprises at least two separable sections, and the hollow doll head is removed from the second mold interior core by separately and individually removing each separable core section from the head through the opening.

21. (original) The process of claim 1, wherein at least one of the interior core separable sections of the second mold is a key section that must be removed first to allow other separable sections to be later removed.

22. (currently amended) The process of claim 21, wherein after the interior core separable sections of the second mold are removed from the deformable hollow thermoplastic ~~article~~ doll head, the sections are reassembled and replaced in the exterior of the second mold for forming another deformable hollow thermoplastic ~~article~~ doll head.

23. (original) The process of claim 10, further comprising rooting hair-material to the top of the doll head above and below the part line with a sufficient density such that the part line is not observable to an ordinary observer holding the doll at arms length.

24. (cancelled).

25. (cancelled).

26. (cancelled).

27. (cancelled).

28. (cancelled).

29. (cancelled).

30. (cancelled).

31. (cancelled).

32. (cancelled).

33. (cancelled).

34. (cancelled).

35. (cancelled).

36. (cancelled).

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37. (cancelled).

38. (cancelled).

39. (cancelled).

40. (cancelled).

41. (cancelled).

42. (cancelled).

43. (cancelled).

44. (cancelled).

45. (cancelled).